: CROSSBOLT SPACER

Date:

Friday, 7/14/2006 12:01:08 PM

User:

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Type

Job Number **Estimate Number**  : 27921

: 10993

P.O. Number

: NIA

This Issue

: 7/14/2006

: NC

: 27167

Prsht Rev. : NIA First Issue

**Previous Run** 

Written By

Checked & Approved By

Comment

: Est E 02.06.17

S.O. No. : NA

Now turned on Cobra

: MACHINED PARTS

**Drawing Name** 

Material

**Part Number Drawing Number** 

: D2579 : D2579 REV D

**Project Number** 

**Drawing Revision** 

: D :NIA

: N/A

: 8/15/2006 **Due Date** 

Qty:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 Tube .500 x.058W

1.0

M6061T6T0500W058

Comment: Qty.: 0.3762 f(s)/Unit Total: 188.1075 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch M100309 1340"

HARDINGE CNC LATHE SMALL

MS 06/07/23

2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

Deburr.

INSPECT PARTS AS THEY COME OFF MACHINE

M.F.06/071

MS 06/07/23

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: -

Sl 06/07/3

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector					
NCR:		WORK ORDER NON-CONF	ORMANCE (NC	R)								

NCR:		1	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	·	Varisia di an	Approval					
DATE	STEP	Section A	Initial Design MgrAction Description Design MgrSign & Date		Verification Section C	Approval Design Mgr	Approval QC Inspector					
				¥								
				·								

Part No:	PAR #:	Fault Category:	_ NCR:	Yes No DQA:	Date: 06/8/9
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Date:

Friday, 7/14/2006 12:01:09 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 27921

Part Number: D2579

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



D06/08/09 U de 0809

## **Dart Aerospace Ltd**

W/O:		WORK OR	DER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
				¥		10	
NCR:		WORK ORDER NON	I-CONFORMANCE (NO	R)	<b></b>		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Corrective Action Section B				Verification	Annancal	Ammercal		
DATE	STEP	Description of NC Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector		
					·-					
				•			(*• ·			
	**									

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	/C C	osed:	Date:

DART AEROSPACE LTD	Work Order:	27921
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.070	+/-0.030	210.F	-			
0.058	+/-0.010					
	0.058	0.058 +/-0.010	0.058 +/-0.010 OS6	0.058 +/-0.010 ,056	0.058 +/-0.010 ,056	0.058 +/-0.010 ,056

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 6667123	Date: 0(0/07/27	Date:	

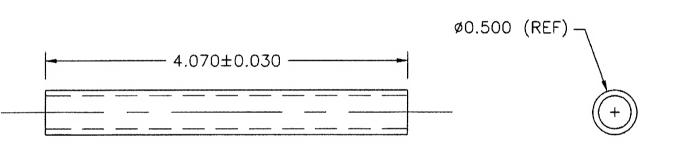
Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	. 14





	DESIGN	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
•	CHECKED	APPROYED	DRAWING NO. REV. D
•	#	HE	D2579 SHEET 1 OF 1
	DATE	V	TITLE SCALE
	99.05.19		CROSS BOLT SPACER 1:1
	A.	96.09.16	NEW ISSUE
	В	96.12.05	0.065 WALL WAS 0.035 WALL
	С	97.02.21	0.058 WALL WAS 0.065 WALL
	D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)





MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-\$\)\text{OO} \( \frac{A}{2} \)\text{RETURN TO}

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED RING UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 27921